










File: Friday, 4/20/2007 2:13:07 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW
Job Number	: 31964A		
Estimate Number	: 10803		
P.O. Number	: N/A	Part Number	: D206642641
This Issue	: 4/20/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3288 REV.C
First Issue	: N/A	Project Number	: N/A
Previous Run	: 31963A	Drawing Revision	: C
	Type : LANDING GEAR	Material	: N/A
Written By	:	Due Date	: 5/10/2007
Checked & Approved By	:	Qty:	1 Um: Each
Comment	Est Rev:B 05.11.15 Added washers for aft cap, wearshoes and ring EC Est Rev:C 06-05-31 Revised steps JLM Est Rev:D 07-02-22 Added SS Wearplates & Gaskets JLM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
			
Comment: DOCUMENT CONTROL Photocopy bluefile and create labels per PPP D206-642-641 CHG002			
2.0	D2620	Bent 206 Skidtube	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2620 3" OD Bent Tube B31487 Pm 07-04-240			
3.0	D2647	Cap	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2647 Fwd Cap B29328 BE 07-04-24			
4.0	D32861	Doubler	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3286-1 Doubler B29090 Pm 07-04-26 ①			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr FWD edge of tube, grind bending marks.

Pm 07-04-24 ①

2-Remove ridge on inside of fwd edge of tube as per Dwg D3288.

Pm 07-04-24 ①

3-Weld Fwd Cap as per Dwg D3288, Grind to obtain proper fit

A/R AL ROD

Batch: M 102421 BE 07-04-24

4-Grind welds flush to cap on top surface only.

BE 07-04-24

5-Cut Aft end as per Dwg D3288 from front of tube then deburr

Pm 07-04-25 ①

6-Remove inner indexing ridge on aft end as per Dwg d3288

Pm 07-04-25 ①

7-Open holes for aft cap as per Dwg D3288 using Dt8025

Pm 07-04-26 ①

8-Drill pilot holes using DT8818

Pm 07-04-26 ①

9-Insert D3286-1 doubler using DT8732 & DT8879, then locating doubler off the D3286-1 doubler, leave Dt8732 for added support

3/16" holes cleco

Pm 07-04-26 ①

10-Drill D3286-1 doubler rivet holes in tube using #40 drill, spot, drilling doubler at the same time.

Pm 07-04-26 ①

11-Working from center out, drill #30 holes into D3286-1 Doubler. cleco each hole after its drilled, Verify angle of holes to accomodate rivet heads.

Pm 07-04-26 ①

12-Remove 3/16" clecos only and open GHW holes to .500" as per Dwg D3288.

Pm 07-04-30 ①

13-Remove D3286-1 doubler, identify orientation, deburr then attach to W/O

Pm 07-04-30 ①

14-Remove indexing edge as per Dwg D3288.

Pm 07-04-30 ①

15-C'sink rivet holes as per Dwg D3288.

Pm 07-04-30 ①

6.0

QC5

INSPECT WORK TO CURRENT STEP



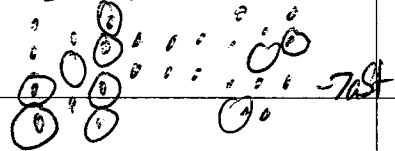


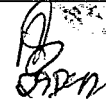
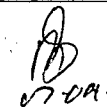
Comment: INSPECT WORK TO CURRENT STEP

DP 7-5-1

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/06/14

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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07-04-27		Bit wandered ovalizing holes RH 		Still in with weld and redrill	BE 07-04-30	 07-05-01		 07-04-27

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Seq. #:

Machine Or Operation:

Description:

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



fm 07-05-01



Comment:

SI 005 4.1

INSPECT POWDER COAT/CHEMICAL CONVERSION



CONVERSION

BE 07-05-01

Cherry Rivet



2.0000 Each(s)

46

~~m102520~~

~~m10280926~~

20

m10209217

fm 07-05-01

Float Web (206A/B)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3289-041 Float Web

B24864

fm 07-05-01

11.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Locate, install and rivet doublers as per Dwg D3288. Micro-shave rivets as required.

2-Bond web in place as per Dwg D3288 & QSI 015.

A/R - Sikaflex-291

m103561

Sikaflex expire date:

07-10-01

Start: 07-05-01

Time: 2:15pm

Finish: 07-05-01

Time: 10:30

(Adhere for 12 hours)

fm 07-05-01

PTO

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: RD Date: 07/06/14
 QA: N/C Closed: _____ Date: _____

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07-05-01	11.0	1 hole in the doubler didn't match up with the hole in the tube.	<i>[Signature]</i> 05/04/12	Remove rivets in doubler, fill hole in the doubler with weld as per Q51042 & grind flush. re-install doubler & locate, drill out the hole as per DWG, and install with new rivets B 102809	<i>[Signature]</i> 07-05-02 <i>[Signature]</i> 07-05-02 BE 07-05-02	<i>[Signature]</i> 07-05-02	<i>[Signature]</i> 05/04/12	<i>[Signature]</i> 07-05-01

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Seq. #:

Machine Or Operation:

Description:

13.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube using program D3288 as per Dwg D3288. Install drop pins in cross bolt spacer holes to maintain web position.

DP 7-6-7

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes for wearplates using D3288-T2 as per Dwg D3288, then open to Ø0.297". (without cutting fluid)

DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)

2-Open x-BOLT holes as per Dwg D3288.

3-C'sink X-bolt holes.

4-Debur.

DP 7-6-7

15.0

D2649

Crossbolt Spacer



Comment: Qty.: 9.0000 Each(s)/Unit Total: 9.0000 Each(s)

Pick:

Qty Part Number Description Batch

9 D2649 Crossbolt spacer 31926 BE 07-06-07

16.0

D32751

Crossbolt Spacer



Comment: Qty.: 9.0000 Each(s)/Unit Total: 9.0000 Each(s)

Pick:

Qty Part Number Description Batch

9 D3275-1 Crossbolt spacer 21748 BE 07-06-07

W/O:		WORK ORDER CHANGES					
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QA: N/C Closed: _____ Date: _____

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Job Number: 31964A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description:

17.0

D32863

Spacer



Comment: Qty: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number:

Description Batch

2 D3286-3

Spacer

D 29015 BE 07-06-11

18.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3288. Remember to back drill each hole before welding the other side. Use aluminum rod.

A/R Aluminum Rod

M 102421 BE 07-06-07

2-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3288. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required

A/RSS Rod

NONE BE 07-06-11

3-Grind welds flush to Fwd cap on top surface only.

BE 07-04-24

4-Grind cross bolt welds flush as per Dwg D3288. Masking Tape access to inside of the skidtube

pm 07-06-08

5-Counterbore 5/16" x 0.750" deep using DT8747, except 8th cross bolt hole from Aft end, as per Dwg D3288.

pm 07-06-08

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

QC5

QC9 11/06/11

20.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR

07-06-12

①

21.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

20-06-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 31964A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D3415041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3415-041 Nut Plate

B30837

23.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivet

m14651

24.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CR3212-4-03 Rivet

m15918

25.0

ALS71032130

Insert



Comment: Qty.: 64.0000 Each(s)/Unit Total : 64.0000 Each(s)

Insert

Batch:

m103495

fel

07/06/13 ①

26.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D3415-041 Nut Plate as per Dwg D3288 ,Install with LPS-3

A/R LPS-3 Batch:

m109161

2-Install inserts Dwg D3288. Use a drop of Sikaflex inside insert holes

A/R Sikaflex-291

m103561

Sikaflex expire date:

07/10

fel

07/06/13 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 31964A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
Inserts & Nut plate

27.06.13 @

28.0

D353515

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: *B30750 B31920*

29.0

D353521

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: *B31991*

30.0

D353535

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: *B31992*

31.0

D353541

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: *B31993*

32.0

D353615

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch: *B31994*

33.0

D353621

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
B31995

FL 07/06/12 @

W/O:		WORK ORDER CHANGES					
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Job Number: 31964A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

D353635

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B31996

35.0

D353641

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B31997

36.0

D35371

WEARPAD



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

WEARPAD

Batch: B31937

37.0

D35373

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

Batch: B32071

38.0

AN3C4A

BOLT



Comment: Qty.: 66.0000 Each(s)/Unit Total : 66.0000 Each(s)

BOLT

Batch: m104291 (60X) m103641 (x6)

39.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 NAS1515H3L Washer m102535

40.0

AN960C10L

washer



Comment: Qty.: 64.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number Description Batch

FL 07/06/12 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

64 AN960C10L Washer *m102602*

41.0

D34131

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3413-1 Ring *B24869*

42.0

AN4C5A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 AN4C5A Bolt *M 18918*

43.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 AN960JD416 Washer *m103338*
AN960C416

44.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2646 Aft Cap *B-50119*

45.0

AN960C10L

washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 AN960C10L Washer *m102602*

Fel 07/06/12

W/O:		WORK ORDER CHANGES					
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Description :

46.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

2-Install wearshoes/wearpads & Gaskets as per Dwg D3288.

3-Install Ring on Nut Plate as per detail F & Dwg D3288.

4-Spray inside tube with LPS-3 on both sides of web

5-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291

Sikaflex expire date:

m103561
07/10

FL 07/06/14
①

6-Coat all exposed fastners with LPS Procyon, remove any excess on powder coat with MEK Degreasser.

A/R LPS Procyon

Batch: *m104251*

47.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20706-14 ①

48.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-641

Location:

PPP Rev:

PPP

B 3.270.8

07/06/14 ①

49.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/14 ①

Job Completion



11 07.06.14

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3288	REV. C SHEET 1 OF 3
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY SCALE NTS	
A	04.05.17	NEW ISSUE	
B	05.03.16	CHANGE INSERTS	
C	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

RELEASED07.02.12 *[Signature]*

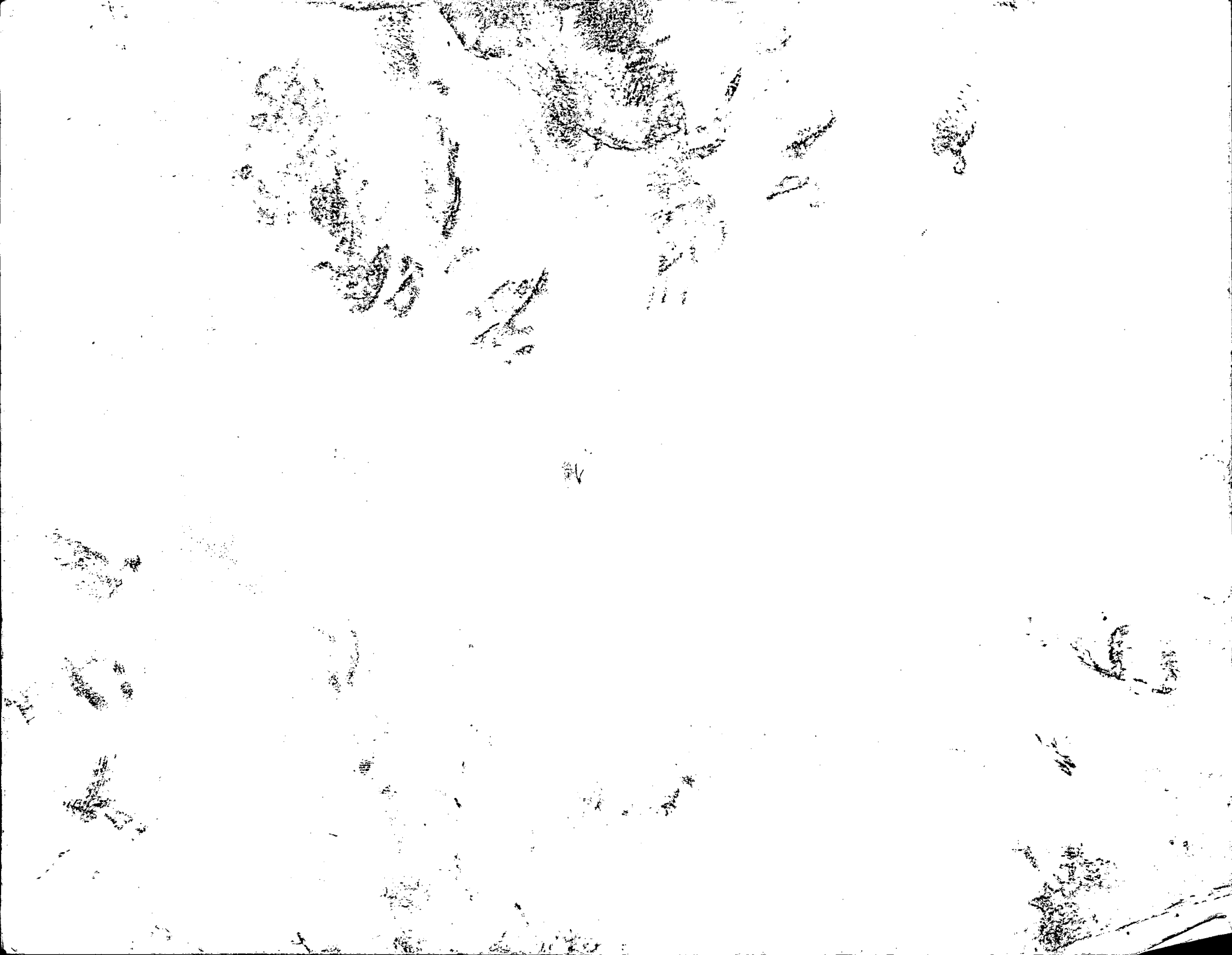
Qty -041	Part Number	Description
X	D3288-041	SKIDTUBE ASSEMBLY
1	D2600-1-240	EXTRUSION
1	D2647 ✓	CAP
1	D2646 ✓	AFT CAP
9	D2649 ✓	CROSS BOLT SPACER
9	D3275-1 ✓	CROSS BOLT SPACER
2	D3286-1 ✓	DOUBLER
2	D3286-3 ✓	SPACER
1	D3289-041 ✓	FLOAT WEB
1	D3413-1 ✓	RING
1	D3415-041 ✓	NUT PLATE
1	D3535-15 ✓	WEARSHOE
1	D3535-21 ✓	WEARSHOE
1	D3535-35 ✓	WEARSHOE
1	D3535-41 ✓	WEARSHOE
1	D3536-15 ✓	GASKET
1	D3536-21 ✓	GASKET
1	D3536-35 ✓	GASKET
1	D3536-41 ✓	GASKET
7	D3537-1 ✓	WEARPAD
1	D3537-3 ✓	WEARPAD
64	ALS7-1032-130 ✓	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
66	AN3C4A ✓	BOLT
1	AN4C5A ✓	BOLT
1	AN960C416 ✓	WASHER
66	AN960C10L ✓	WASHER
2	CCR264SS3-3 ✓	RIVET
2	CR3212-4-03 ✓	RIVET
52	CR3212-4-04 ✓	RIVET
2	NAS1515H3L ✓	WASHER

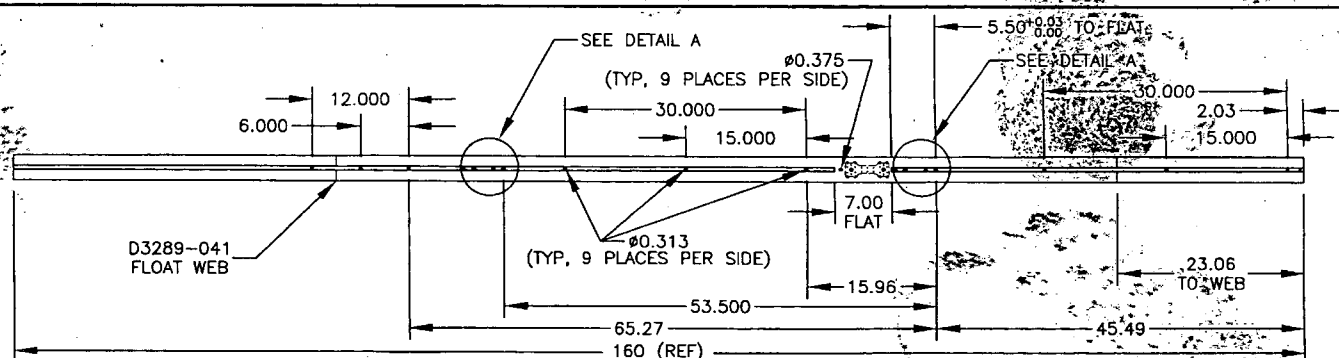
GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3289-041 FLOAT WEB INTO D3288-1 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH:
 - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
 - POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3288-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

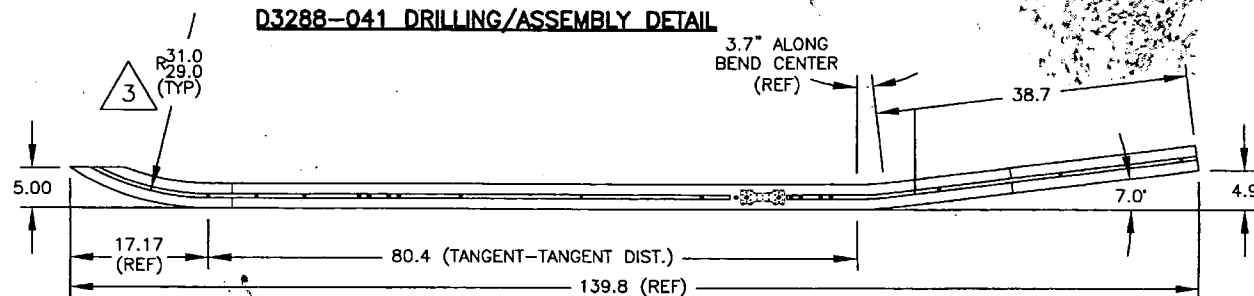
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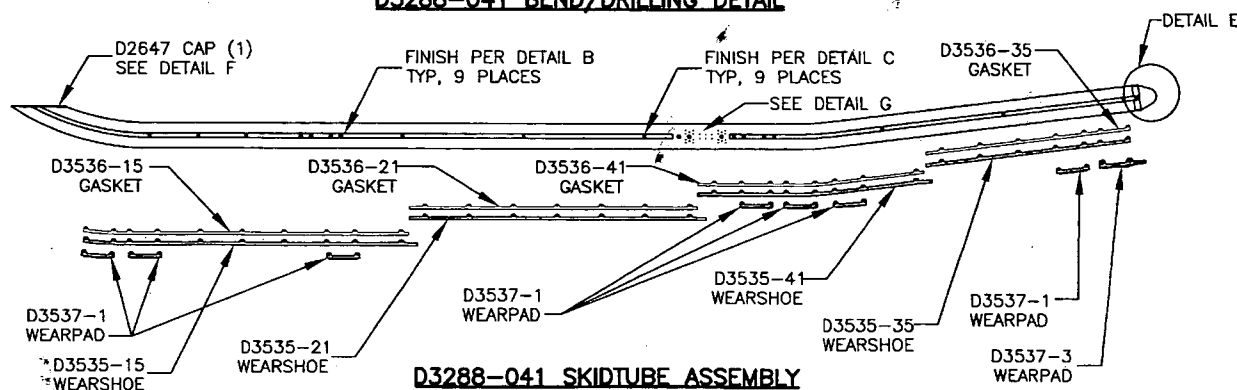




D3288-041 DRILLING/ASSEMBLY DETAIL



D3288-041 BEND/DRILLING DETAIL



D3288-041 SKIDTUBE ASSEMBLY

RELEASED

07-02-12

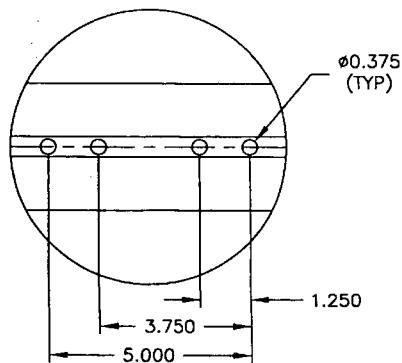
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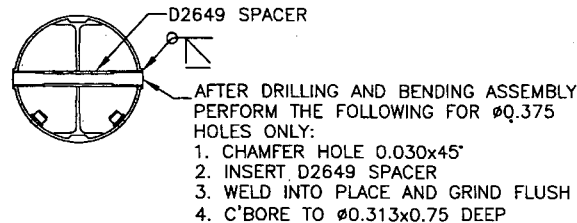
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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA	REV. C
CHECKED	#	APPROVED	#	DRAWING NO. D3288	SHEET 2 OF 3
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	SCALE	1:15

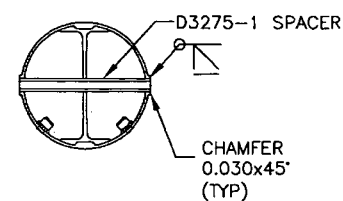
DETAIL A: DRILL DETAIL



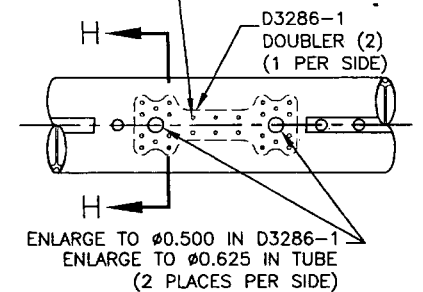
DETAIL B FOR 0.375 HOLES ONLY



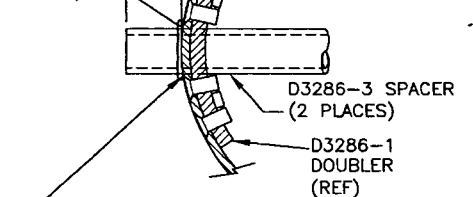
DETAIL C FOR 0.313 HOLES ONLY



DETAIL G SCALE 1:5

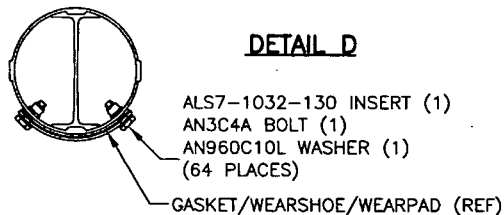


SECTION H-H NOT TO SCALE



- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO 0.500
 4. ENLARGE HOLES IN TUBE TO 0.625
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

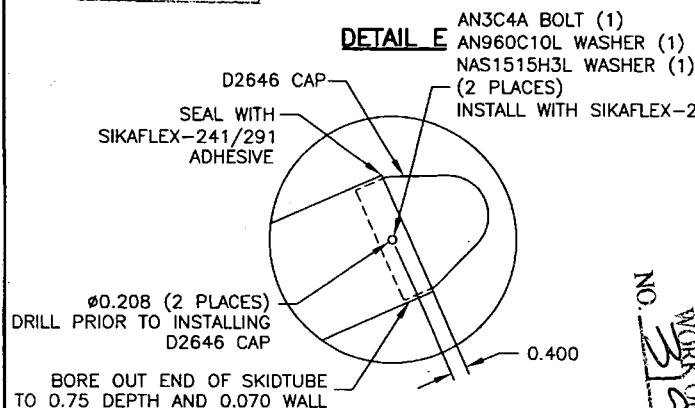
DETAIL D



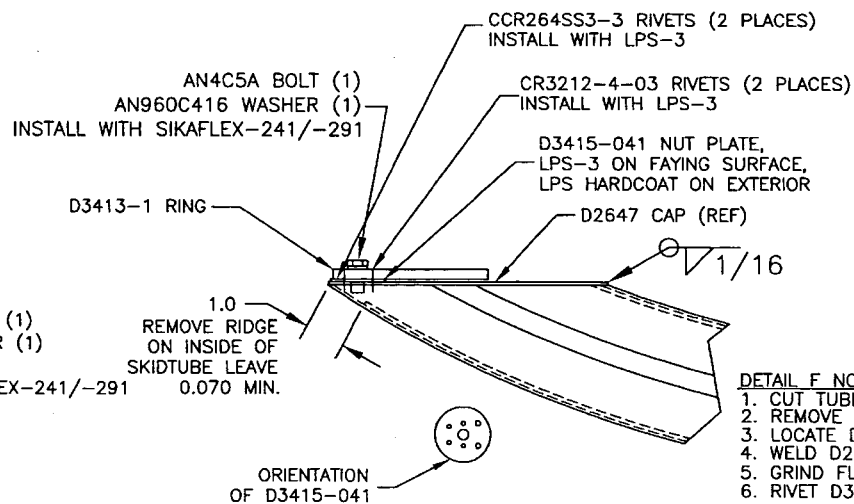
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07.02.12

DETAIL E



DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

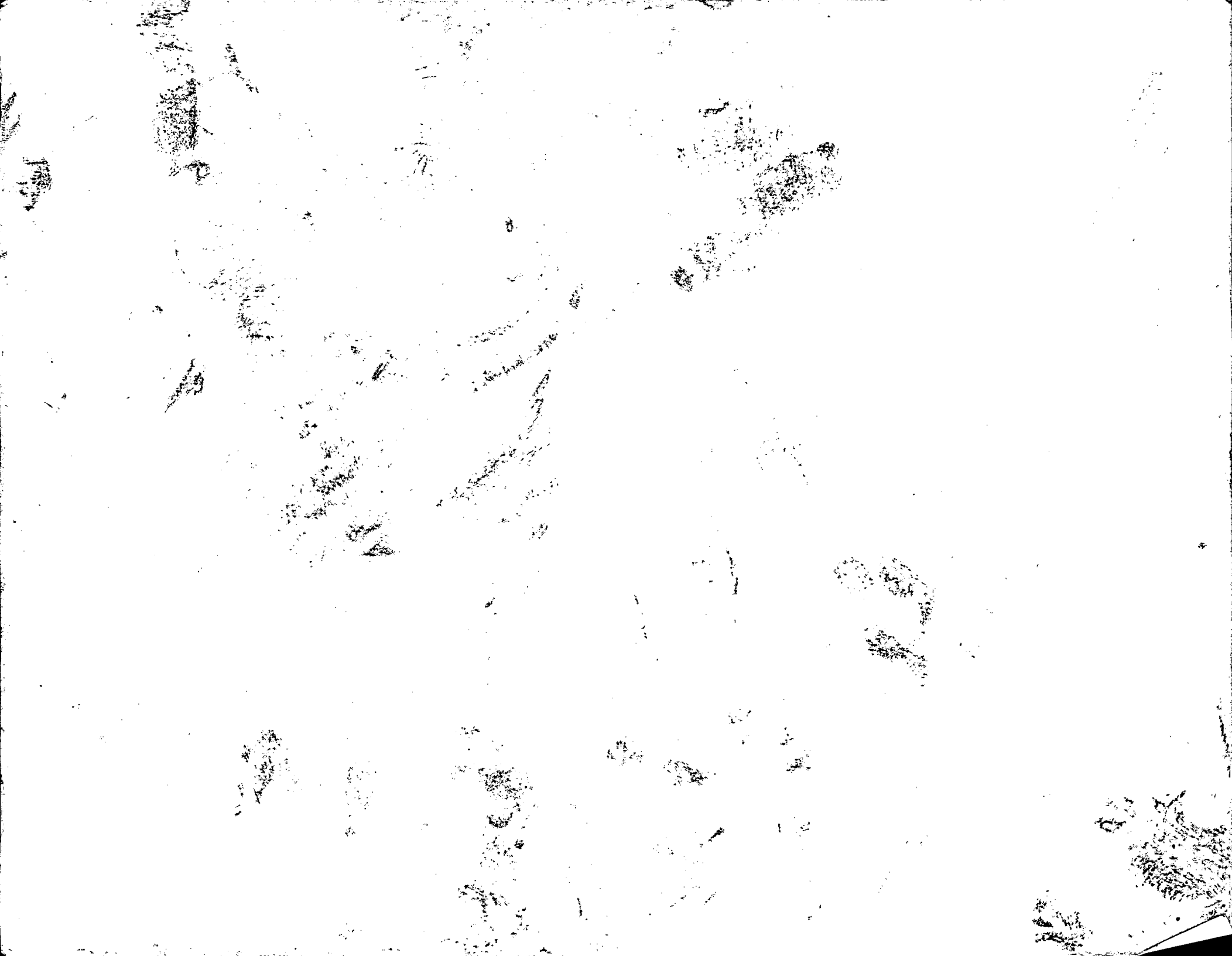
NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED	#	APPROVED	#	DRAWING NO. D3288
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. C SHEET 3 OF 3 SCALE 1:3



NO. 110

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number D206642441 / B31983A

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into NA Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/05/29

Qualifier David Dussal